SHIP TODAY

Work Order ID 51560

August 26, 2009 10:01:27 AM

Item ID: D3183-045
Revision ID: C1
Item Name: Bearing Assembly

Accept

Setup Start
Stop

Start Date: 8/26/09 **Start Qty:** 10.00
Required Date: 8/26/09 **Req'd Qty:** 10.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3183	**Revision Nbr** Rev C1								
130 Small Fab	Small Fab	0.00							
	Memo	0.00							
Small Fab	Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.								
140 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: 236A	0.00							
	Memo	0.00							

09/08/26 (10)

=> 8 or 08/26

(40)

9/8/26 (10) SP

Work Order ID 51560

August 26, 2009 10:01:27 AM

Item ID: D3183-045
Revision ID: C1
Item Name: Bearing Assembly

Start Date: 8/26/09 **Start Qty:** 10.00
Required Date: 8/26/09 **Req'd Qty:** 10.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

09/08/26 KJ

W 09.08.26

Picklist Print

August 26, 2009 10:01:26 AM

Work Order ID: 51560

Parent Item: D3183-045RevC1

Parent Item Name: Bearing Assembly

Comments:

Start Date: 8/26/09 **Required Date:** 8/26/09

Start Qty: 10.00 **Required Qty:** 10.00

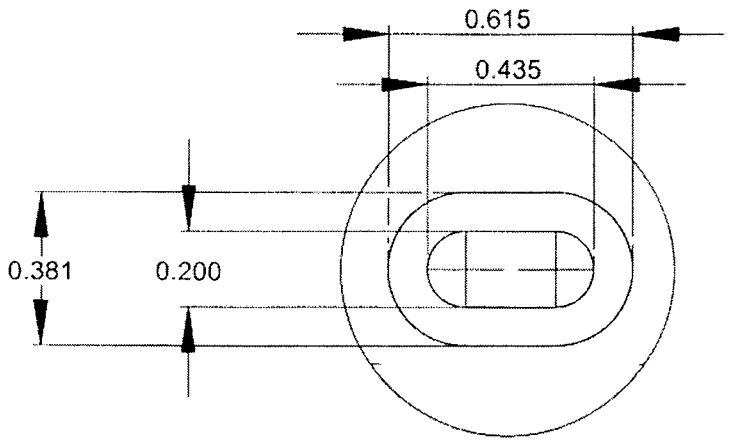
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3183-5RevC1		Manufactured	No			110	Each	202.0000	10.0000		09/08/26	
Bearing												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	202		
46853	2		
47385	2		
47606	2		
47675	196		10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3183-9RevC1		Manufactured	No				Each	33.0000	10.0000		09/08/26	
Cap												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	33		
31762	1		
47648	32		10

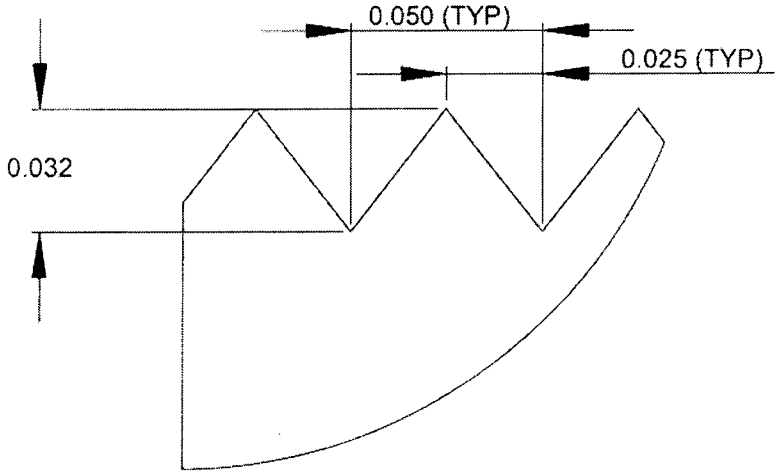
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



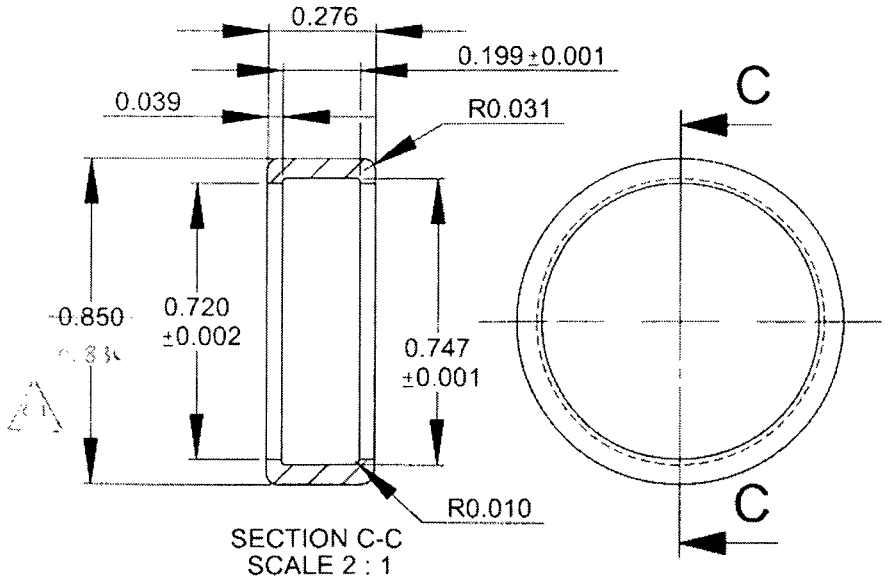
DETAIL A (2 : 1)

w/o 51560

RELEASED



DETAIL B (20 : 1)



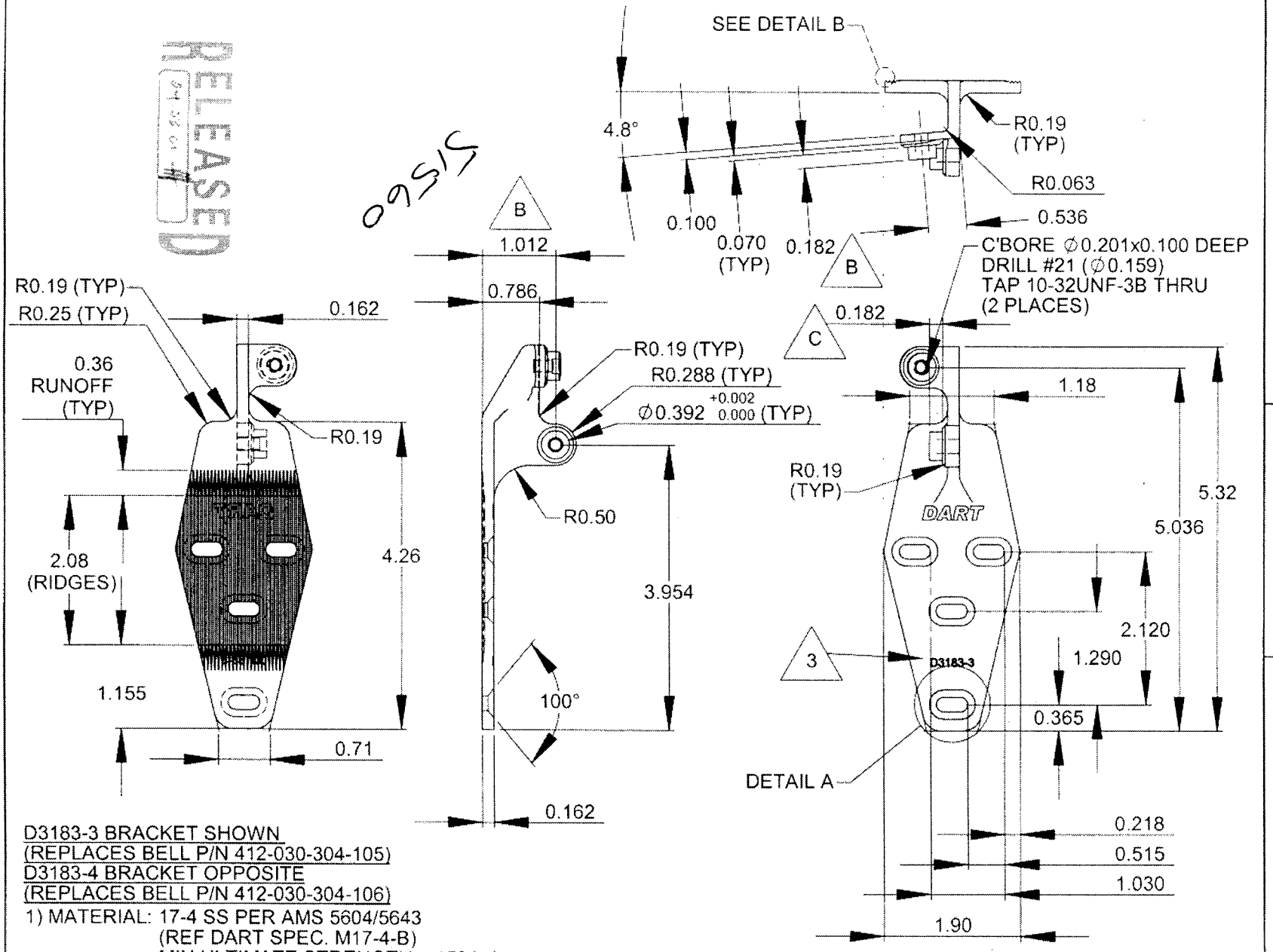
SECTION C-C
SCALE 2 : 1

D3183-9 CAP

1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP



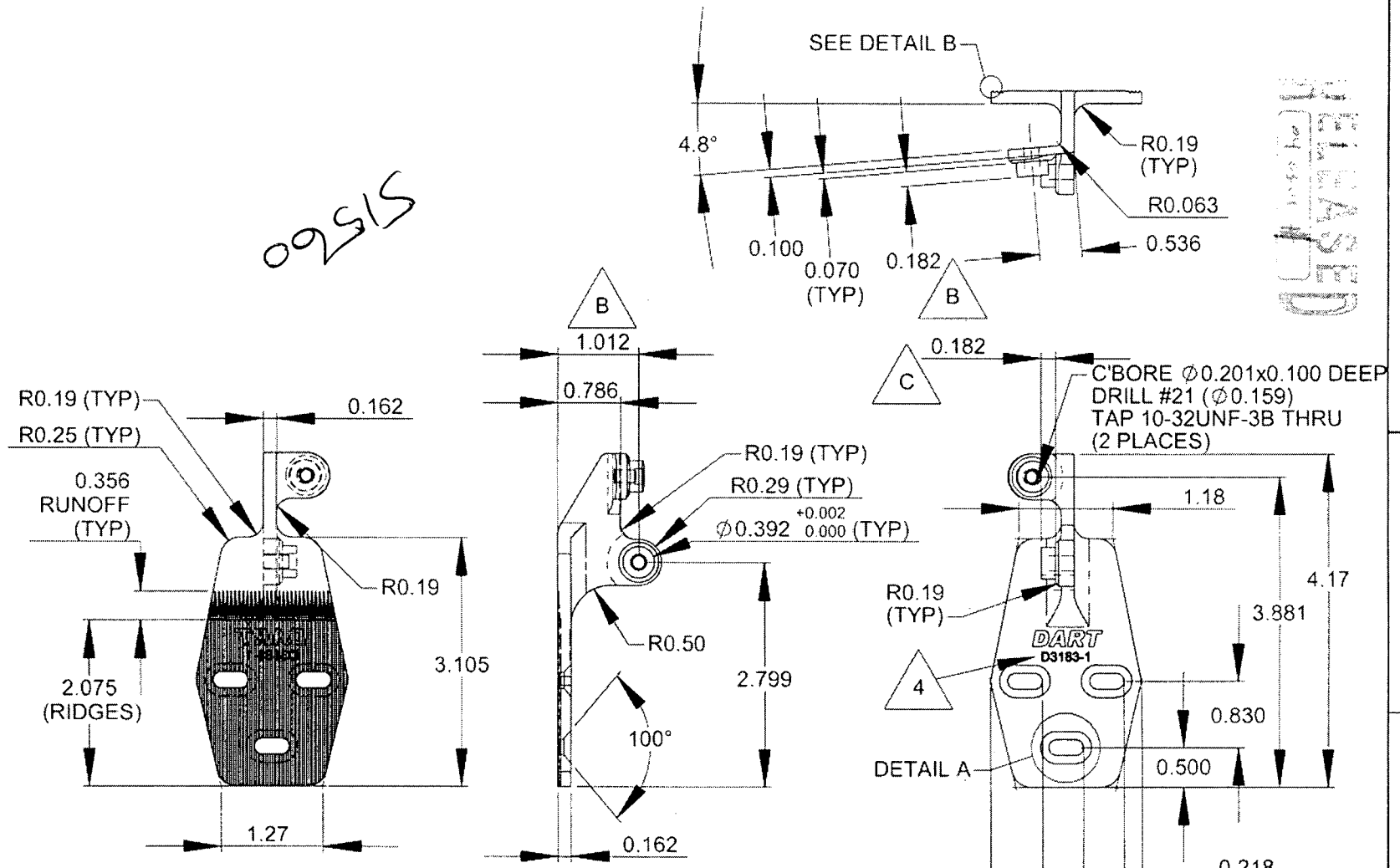
RELEASED

D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
TITLE BRACKET ASSEMBLY	SCALE 1:2	SHEET 3 OF 4



09515

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

1) D3183-1 CAN BE MADE FROM D3183-3
   D3183-2 CAN BE MADE FROM D3183-4
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE STRENGTH = 150 ksi
   MIN YIELD STRENGTH = 100 ksi
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

RELEASED

DART

DESIGN
CHECKED
APPROVED
DRAWN BY
DATE 04.02.17

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

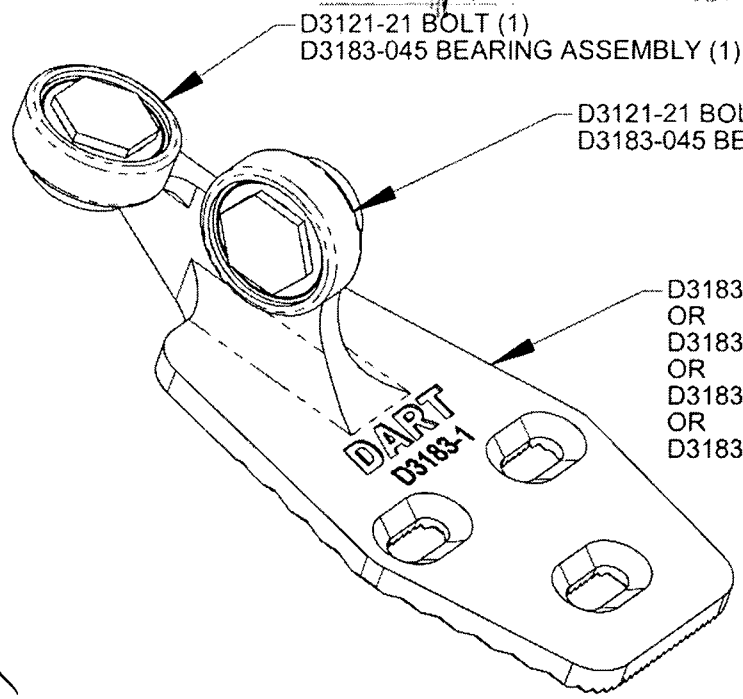
DRAWING NO. D3183
REV. C
SHEET 2 OF 4
SCALE 1:2

TITLE
BRACKET ASSEMBLY

DESIGN		DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED	DRAWING NO. D3183 REV. C SHEET 1 OF 4
DATE 04.02.17			TITLE BRACKET ASSEMBLY SCALE 1:1

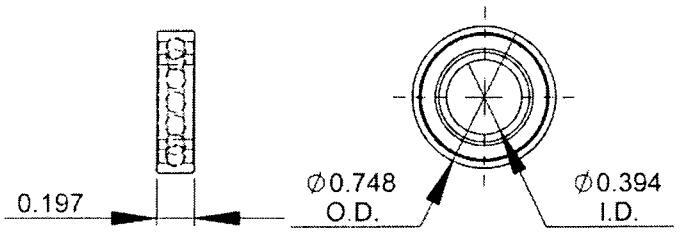
A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.10.07	0.830 WAS 0.850

RELEASED 04 03 01



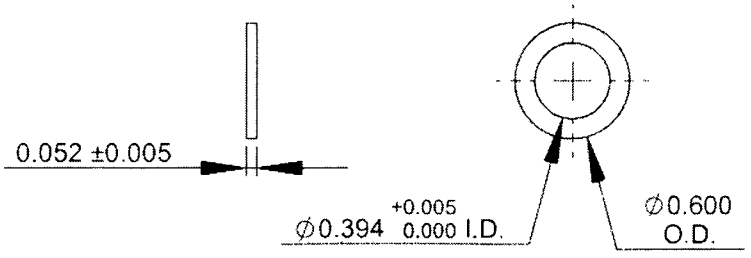
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

5560



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES